






Work Order ID 55321



January 13, 2010 10:21:59 AM



Page 1

Item ID: D2583 Accept  Setup Start 
Revision ID: Stop 
Item Name: Latch Bracket
Start Date: 1/13/10 Start Qty: 40.00  Cust Item ID:
Required Date: 1/20/10 Req'd Qty: 40.00  Customer:

Reference:

Approvals: Process Plan: *RL* Date: *10-1-13* Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2583	Rev B
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100	FLOW WATER JET	0.00
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Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2583 [1] Dwg Rev: *B* [2] Prog Rev: *B* [12]-
Deburr if necessary

Q52 .640

10-1-21

56

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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QC

Memo

0.00

Quality Control

10-1-21

120	QC8- Inspect parts - second check	0.00
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QC

Memo

0.00

Quality Control

⇒ 10/01/22

location
(X55)

Pro ⇒

W/O: 55321		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/1/22	#120	Took Qty +1 For inspection template	S	10/01/22	4		S 10/01/22

Part No: D2583 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55321

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Item ID: D2583

Accept



Setup Start



Revision ID:

Stop



Item Name: Latch Bracket

Start Date: 1/13/10 Start Qty: 40.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Debur Form on CNC Brake as per Dwg D2583

SB 10/01/28

55

0

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ Sidelogs

10/01/28
55

0

Quality Control

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

PK 10-02-01

55

0

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

7/11 10-2-04

X55

Powder Coating

START TIME: 10:00am OVEN TEMPERATURE:
10:30am FINISH TIME: 3:20pm

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

BA 10-02-4

55

Quality Control

180

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

1/10/11 55

Packaging

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Approvals: Process Plan:

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Date:

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/11

MF

10-2-11

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NOTE: Date & initial all entries

Picklist Print

January 13, 2010 10:22:03 AM

Page 1

Work Order ID: 55321



Parent Item: D2583

Parent Item Name: Latch Bracket

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP: C000.11.0103Removed P/O for Powder Coat- in house process DM
IPP: D006.07.21 Waterjet EC

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	116.1568	4.9221	7.1		



1810-1-21

5052-H32.040 Sheet

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	116.1568	
101875	6.625	
104921	3.3568	
106900	2	
107513	4.5	
109058	35.675	
113123	64	

113123

56

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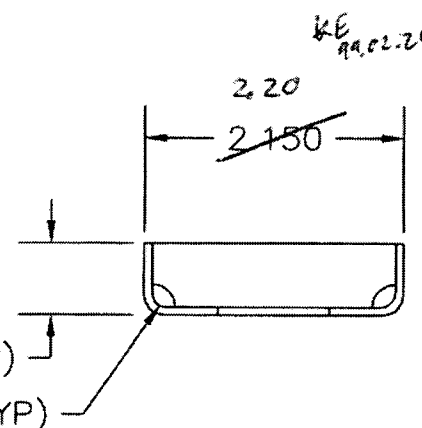
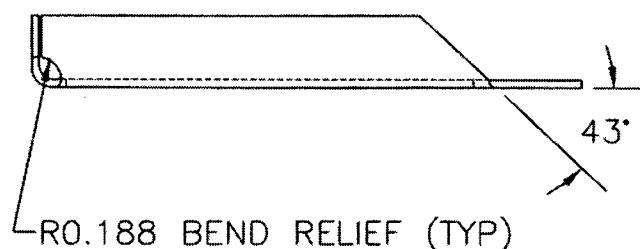
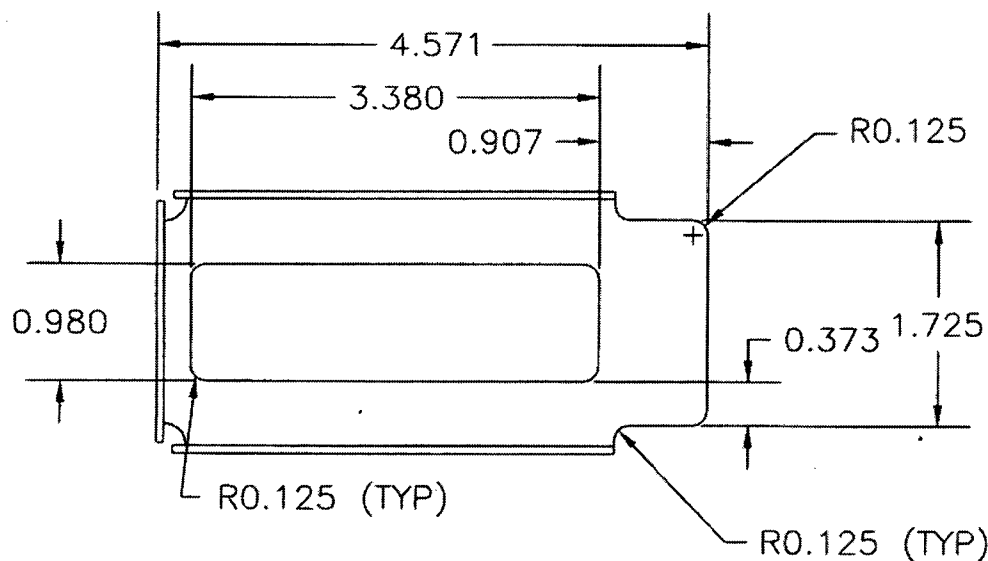
NOTE: Date & initial all entries

DART



RELEASED
KE 99.02.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55321



DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	KE	DRAWING NO. D2583
DATE	99.02.22	TITLE	LATCH BRACKET	SHEET 1 OF 1 SCALE 2:3
A	96.07.10	NEW ISSUE		
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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